

Date: Wednesday, 1/11/2006 4:30:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 25480	
Estimate Number : 10869	
P.O. Number : N/A	Part Number : D32161
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D3216 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/31/2006
Checked & Approved By : <u> </u>	Qty: 151 Um: Each
Comment : Est: A 03.10.28 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 377

Email or Ship DXF file to vendor

Laser Cut D3216-1 Fitting as per Dwg D3216

Material release note is required

06-01-12

150

2.0	D32161F	Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 150.0000 Each(s)
 Fitting

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C206/02/08

(152)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06-02-09

153

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

DC 06/02/17

151

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:11 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 25480

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06/02/20 151

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

546 06/02/21

151

06/02/21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

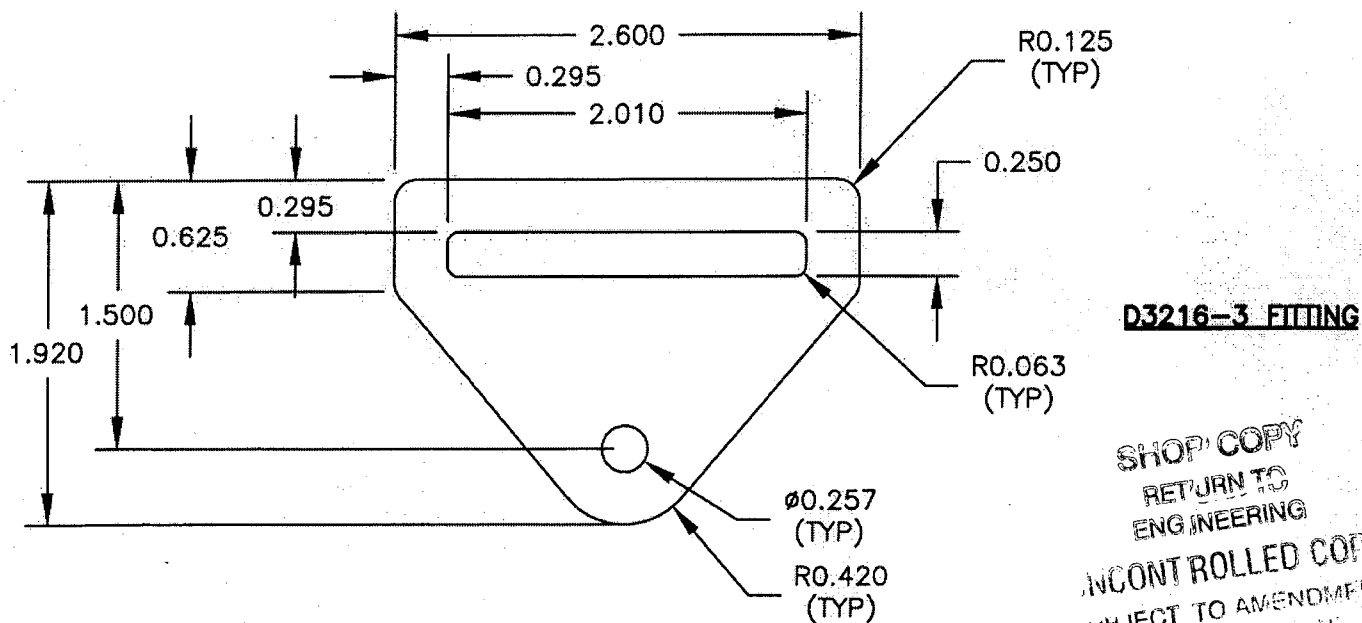
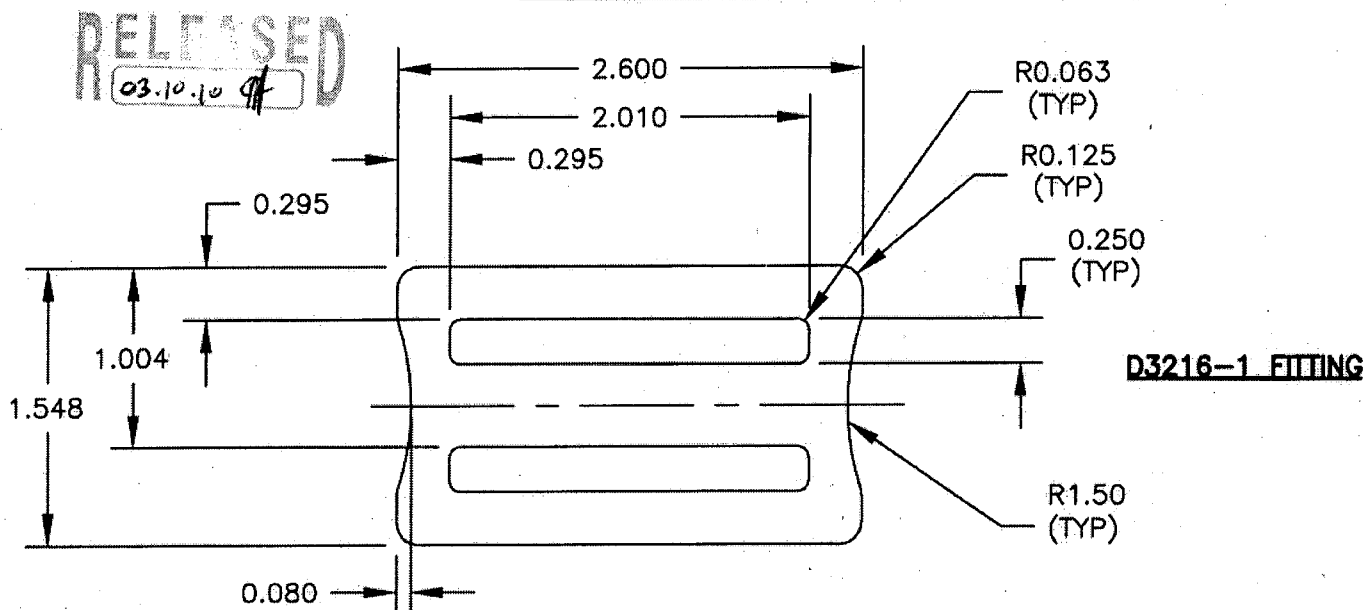
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



D3216-1/-3 FITTING

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 25480

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P41123PC002
 Issued in accordance to Pressure Equipment Direct. /23/EC Annex I,
 Paragraph 4.3 by TÜV Aegiertechnik GmbH (Notified Body Identification No. 0035)
 Inspection Certificate EN10204-3.1B

Taiyuan Iron and Steel(Group)Co.,LTD

NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
 http://www.tisco.com.cn
 E-mail: tgbxg@tisco.com.cn

INSPECTION CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	200412110	
DATE OF ISSUE	11	

CUSTOMER
 Marubeni Techno Steel Co.

CONTRACT NO.

DATA OF
 2004/12/20

Product

Melting Furnace

Inspector's stamp

Mark of the Manufacturer

COIL

E+VOD



Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
1	4405025	4A11-303-12B	1	11GA x 48 x C	4358
2	4404509	4A10-356-12B	1	14GA x 48 x C	3920
3	QHLL0164	4A12-141-32J	1	14GA x 48 x C	4972
4	Y408037	4A12-373-42D	1	12GA x 48 x C	4382
5	Y408037	4A12-374-42D	1	12GA x 48 x C	4347
6	Y408037	4A12-375-42D	1	12GA x 48 x C	4257
7	4405608	4A12-341-12J	1	12GA x 48 x C	3793

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4405025	0.060	0.470	1.340	0.020	0.002	18.050	8.100				0.059
4404509	0.050	0.470	1.350	0.021	0.002	18.080	8.120				0.060
QHLL0164	0.052	0.546	1.077	0.027	0.003	18.300	8.080				0.044
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
4405608	0.060	0.510	1.350	0.021	0.002	18.090	8.100				0.055

Mechanical Properties

Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A _{5%}	Corrosion Tests	Hardness		
						HRB	HV	HRC
4405025-T	610	255		65		83		
4404509-T	655	265		61.5		84		
QHLL0164-T	660	275		58.5		83		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
Y408037-T	660	260		64		85		
4405608-T	665	265		61.5		84		

Surface and dimensions controlled:

Work Inspector: 



P/O 377